



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

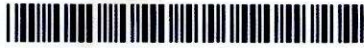
D3238-21
Job Sheet 212191



Part No: D3238-21

Job Qty: 6 pcs

Part Name: Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/20

Job Tracking No:

Due Date: 8/21/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A New Issue 07-01-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		8/20/20	0.17	0.29	Waterjet - Flow		on 20/08/14
110	Conventional Mill - 1 - B4B	6 pcs		8/20/20	0.00	4.93	Conventional Mill - 1 - B4B		P. Lajeunesse
							Conventional Mill - 2 - B4B		
120	QC 2	6 pcs		8/20/20	0.00	0.00	QC 2 - 1		P. Lajeunesse
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

PRIORITY

				QC 2 - 8		
				QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
				QC 2 - 76		
				QC 2 - 86		
				QC 2 - 83		
130	Waterjet - Flow - B4B	6 pcs	8/20/20	0.17 0.29	Waterjet - Flow - B4B	on 20/08/14
140	QC 2	6 pcs	8/20/20	0.00 0.00	QC 2 - 1	
				QC 2 - 12		
				QC 2 - 14		
				QC 2 - 17		
				QC 2 - 19		
				QC 2 - 2		
				QC 2 - 20		
				QC 2 - 22		
				QC 2 - 23		
				QC 2 - 25		
				QC 2 - 32		
				QC 2 - 33		
				QC 2 - 35		
				QC 2 - 39		
				QC 2 - 4		
				QC 2 - 40		
				QC 2 - 44		
				QC 2 - 45		
				QC 2 - 48	on 20/08/14	
				QC 2 - 49		
				QC 2 - 50		
				QC 2 - 51		
				QC 2 - 52		
				QC 2 - 57		
				QC 2 - 62		
				QC 2 - 63		
				QC 2 - 8		
				QC 2 - 66		
				QC 2 - 64		
				QC 2 - 65		
				QC 2 - 5		
				QC 2 - 71		
				QC 2 - 73		
				QC 2 - 69		
				QC 2 - 76		
				QC 2 - 86		
				QC 2 - 83		
150	QC 8	6 pcs	8/20/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
				Plex 8/13/20 8:55 AM Dart.lajeunesse.marie		

				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	AUG 14 2020 DAS 40
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
160	Handfinish - 1-1 Chemical-B4B	6 pcs	8/21/20	0.00 0.17	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
170	QC 3	6 pcs	8/21/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68

Plex 8/13/20 8:55 AM Dart.lajeunesse.marie

						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
						QC 3 - 82	DAS 31 9-89
						QC 3 - 87	AUG 17 2020
						QC 3 - 47	
180	Packaging 3-1 - Stock - B4B	6 pcs	8/21/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	DAS 28 9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	AUG 17 2020
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
						Packaging 3 - 37 - B4B	DAS 21 9-89
190	QC 21 - SA	6 pcs	8/21/20	0.00	0.00	QC 21 - SA - 21	AUG 17 2020
						QC 21 - SA - 70	
						QC 21 - SA - 9	
						QC 21 - SA - 77	

Part Op 100 - W/O'S FOR D3238-23-25 MUST BE ISSUED AND RAN AT THE SAME TIME 1-Cut as per Dwg D3238 Dwg
 Descriptions: Rev: C Prog Rev: C 2-Debur if necessary *****USE D3238 BLANK CUTTING FILE****

110 - (Manufacture as per dwg) Machine Serration on Sheet using DT8934 PLATE

120 - QC2- Inspect parts off machine FAI/FAIB

130 - 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-Debur if necessary ***Use cutting file D3238-21-23-25*****

140 - QC2- Inspect parts off machine FAI/FAIB

150 - QC8- Inspect parts - second check

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	1.7400 sf (.29 ea)	100-Waterjet - Flow - 1	S101799

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	2	146	0

Part Specifications

Specifications could not be found.

Plex 8/13/20 8:55 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 212191
Description: Plate		Part Number: D3238-21
Inspection Dwg: D3238	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	Ø.20	1		Via-04	
0.40	+/-0.030	.396	1		" "	
0.33	+/-0.030	.334	1		" "	
1.96	+/-0.030	1.969	1		" "	
1.300	+/-0.010	1.301	1		" "	
1.75	+/-0.030	1.755	1		" "	
0.950	+/-0.010	.950	1		" "	
0.80	+/-0.030	.80	1		" "	
0.65	+/-0.030	.65	1		" "	
.032	±.01	.032	✓		GA-08	
.050	±.01	.05	✓		Thread gauge	

Measured by: P2066/14	Audited by: DAS 40	Prototype Approval:	N/A
Date: 02/20/09/14	Date: AUG 17 2020	Date:	N/A
Rev	Date	Change	Revised by
A	08.02.28	New Issue	KJ/DD
			Approved

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

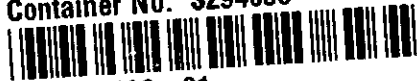
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S294030



Part: D3238-21

Job No: 212191

Serial No/Batch: S294030

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/13/20